



**Welder Performance Qualification Record (WPQ)**

Welder's Name <u>Bernardo Cruz</u>		ID. # <u>9788</u>	Stamp # <u>BC (45)</u>
WPS No. <u>PISL-GTAW-SS</u>			
Welding Process(es) <u>Gas Tungsten Arc Welding (GTAW)</u>		Type <u>Manual</u>	
Base Material(s) <u>SA-106 Gr. B</u>	To <u>SA-106 Gr. B</u>	Thickness <u>0.147"</u>	
<u>Manual or Semi-Automatic Variables for Each Process</u>		<u>Actual Values</u>	<u>Range Qualified</u>
Backing <u></u>		F6- Without	F6-With/Without
ASME P-No. To <u></u> P- No. <u></u>		P1 to P1	P1 to P15E
<input type="checkbox"/> Plate <input checked="" type="checkbox"/> Pipe (enter diameter, if pipe) <u></u>		1/2"	1/2" NPS Minimum
	Root/Fill	5.18	5.18
Filler Metal Specification (SFA) Classification <u></u>		-	-
	Root/Fill	6	6
Filler Metal Group No. <u></u>		-	-
Filler Metal Product Form <u></u>		Solid Rod	Solid Rod
Consumable Insert for GTAW or PAW <u></u>		None	None
	F 6	0.147"	0.294" Maximum
Weld Deposit Thickness <u></u>		-	-
Welding Position <u></u>		6G (Three Coupon)*	All
Maximum Deposition Rate <u></u>		N/A	
Welding Progression (Uphill/ Downhill) <u></u>		Uphill	Uphill
Backing Gas for GTAW, PAW, GMAW or FCAW/G <u></u>		None	With/ Without Argon
GMAW Transfer Mode <u></u>		N/A	N/A
FCAW/ GTAW Welding Current Type/ Polarity <u></u>		DC/ EN	DC/EN
*Remarks: * Total weld length: 7.99"			

Bernardo Cruz

**Guide Bend Test Results**

<input type="checkbox"/> Side	<input checked="" type="checkbox"/> Trans. Root (R) & Face (F)	<input type="checkbox"/> Long. Root & Face	Results
-	T-011419-45-R1-Figure QW-462.3 (a)		Acceptable
-	T-011419-45-R2-Figure QW-462.3 (a)		Acceptable
-	T-011419-45-F1-Figure QW-462.3 (a)		Acceptable
-	T-011419-45-F2-Figure QW-462.3 (a)		Acceptable

Radiographic Test Results: NoneVisual Examination Results: Face: Acceptable Root: AcceptableWelding Test Conducted By: Guillermo Castro, LIIIMechanical Tests Conducted By: Acuren Inspection Services Laboratory Test No. PAUT021621-BC

We certify that the statements in this record are correct and that the test coupons were prepared, welded, tested in accordance with the requirements of ASME Section IX/2013

Organization: Petro Industrial Solutions, LLCBy: Adrian Melendez Jr., PMDate: 02/19/2021**PIS000071**

**PIS000072**

# Welder Performance Qualification Record (WPQ)

Welder's Name Fernando Lebron ID. # 2151 Stamp # FL (52)

WPS No. PISL-GTAW-SS

Welding Process(es) Gas Tungsten Arc Welding (GTAW) Type Manual

Base Material(s) SA-106 Gr. B To SA-106 Gr. B Thickness 0.147"

Manual or Semi-Automatic Variables for Each Process Actual Values Range Qualified

Backing	F6- Without	F6-With/Without
ASME P-No. To P- No.	P1 to P1	P1 to P15E
<input type="checkbox"/> Plate <input checked="" type="checkbox"/> Pipe (enter diameter, if pipe)	1/2"	1/2" NPS Minimum
Root/Fill	5.18	5.18
Filler Metal Specification (SFA) Classification	-	-
Root/Fill	6	6
Filler Metal Group No.	-	-
Filler Metal Product Form	Solid Rod	Solid Rod
Consumable Insert for GTAW or PAW	None	None
F 6	0.147"	0.294" Maximum
Weld Deposit Thickness	-	-
Welding Position	6G (Three Coupon)*	All
Maximum Deposition Rate	N/A	
Welding Progression (Uphill/ Downhill)	Uphill	Uphill
Backing Gas for GTAW, PAW, GMAW or FCAW/G	None	With/ Without Argon
GMAW Transfer Mode	N/A	N/A
FCAW/ GTAW Welding Current Type/ Polarity	DC/ EN	DC/EN

\*Remarks: \* Total weld length: 7.95"

## Guide Bend Test Results

<input type="checkbox"/> Side	<input checked="" type="checkbox"/> Trans. Root (R) & Face (F)	<input type="checkbox"/> Long. Root & Face	Results
-	T-112118-52-R1-Figure QW-462.3 (a)		Acceptable
-	T-112118-52-R2-Figure QW-462.3 (a)		Acceptable
-	T-112118-52-F1-Figure QW-462.3 (a)		Acceptable
-	T-112118-52-F2-Figure QW-462.3 (a)		Acceptable

Radiographic Test Results: None

Visual Examination Results: Face: Acceptable Root: Acceptable

Welding Test Conducted By: Guillermo Castro, LIII

Mechanical Tests Conducted By: Acuren Inspection Services Laboratory Test No. PAUT033021-FL

We certify that the statements in this record are correct and that the test coupons were prepared, welded, tested in accordance with the requirements of ASME Section IX/2013

Organization: Petro Industrial Solutions, LLC

By: Adrian Melendez Jr., PM Date: 04/01/2021

**PIS000073**



# Welder Performance Qualification Record (WPQ)

Welder's Name Jonathan Rodriguez ID. # 7145 Stamp # JR2 (49)

WPS No. PISL-GTAW-SS

Welding Process(es) Gas Tungsten Arc Welding (GTAW) Type Manual

Base Material(s) SA-106 Gr. B To SA-106 Gr. B Thickness 0.147"
Manual or Semi-Automatic Variables for Each Process Actual Values Range Qualified

Backing F6- Without F6-With/Without

ASME P-No. To P- No. P1 to P1 P1 to P15E
☐ Plate ☒ Pipe (enter diameter, if pipe) 1/2" 1/2" NPS Minimum

Root/Fill 5.18 5.18

Filler Metal Specification (SFA) Classification - -

Root/Fill 6 6

Filler Metal Group No. - -

Filler Metal Product Form Solid Rod Solid Rod

Consumable Insert for GTAW or PAW None None

Weld Deposit Thickness 0.147" 0.294" Maximum

Welding Position 6G (Three Coupon)\* All

Maximum Deposition Rate N/A

Welding Progression (Uphill/ Downhill) Uphill Uphill

Backing Gas for GTAW, PAW, GMAW or FCAW/G None With/ Without Argon

GMAW Transfer Mode N/A N/A

FCAW/ GTAW Welding Current Type/ Polarity DC/ EN DC/EN

\*Remarks: \* Total weld length: 7.91"

## Guide Bend Test Results

<input type="checkbox"/> Side	<input checked="" type="checkbox"/> Trans. Root (R) & Face (F)	<input type="checkbox"/> Long. Root & Face	Results
-	T-052918-49-R1-Figure QW-462.3 (a)		Acceptable
-	T-052918-49-R2-Figure QW-462.3 (a)		Acceptable
-	T-052918-49-F1-Figure QW-462.3 (a)		Acceptable
-	T-052918-49-F2-Figure QW-462.3 (a)		Acceptable

Radiographic Test Results: None

Visual Examination Results: Face: Acceptable Root: Acceptable

Welding Test Conducted By: Guillermo Castro, LIII

Mechanical Tests Conducted By: Acuren Inspection Services Laboratory Test No. PAUT033021-JR2

We certify that the statements in this record are correct and that the test coupons were prepared, welded, tested in accordance with the requirements of ASME Section IX/2013

Organization: Petro Industrial Solutions, LLC

By: Adrian Melendez Jr., PM

Date: 04/01/2021
**PIS000074**

# Welder Performance Qualification Record (WPQ)

Welder's Name Richael Philips ID. # 4799 Stamp # RP (51)

WPS No. PISL-GTAW-SS

Welding Process(es) Gas Tungsten Arc Welding (GTAW) Type Manual

Base Material(s) SA-106 Gr. B To SA-106 Gr. B Thickness 0.147"

Manual or Semi-Automatic Variables for Each Process Actual Values Range Qualified

Backing F6- Without F6-With/Without

ASME P-No. To P- No. P1 to P1 P1 to P15E

☐ Plate ☒ Pipe (enter diameter, if pipe) 1/2" 1/2" NPS Minimum

Root/Fill

5.18

5.18

Filler Metal Specification (SFA) Classification

Root/Fill

6

6

Filler Metal Group No.

Filler Metal Product Form

Solid Rod

Solid Rod

Consumable Insert for GTAW or PAW

F 6

None

None

Weld Deposit Thickness

0.147"

0.294" Maximum

Welding Position

6G (Three Coupon)\*

All

Maximum Deposition Rate

N/A

Welding Progression (Uphill/ Downhill)

Uphill

Uphill

Backing Gas for GTAW, PAW, GMAW or FCAW/G

None

With/ Without Argon

GMAW Transfer Mode

N/A

N/A

FCAW/ GTAW Welding Current Type/ Polarity

DC/ EN

DC/EN

\*Remarks: \* Total weld length: 7.91"

## Guide Bend Test Results

<input type="checkbox"/> Side	<input checked="" type="checkbox"/> Trans. Root (R) & Face (F)	<input type="checkbox"/> Long. Root & Face	Results
-	T-082118-51-R1-Figure QW-462.3 (a)		Acceptable
-	T-082118-51-R2-Figure QW-462.3 (a)		Acceptable
-	T-082118-51-F1-Figure QW-462.3 (a)		Acceptable
-	T-082118-51-F2-Figure QW-462.3 (a)		Acceptable

Radiographic Test Results: None

Visual Examination Results: Face: Acceptable Root: Acceptable

Welding Test Conducted By: Guillermo Castro, LIII

Mechanical Tests Conducted By: Acuren Inspection Services Laboratory Test No. PAUT031721-RP

We certify that the statements in this record are correct and that the test coupons were prepared, welded, tested in accordance with the requirements of ASME Section IX/2013

Organization: Petro Industrial Solutions, LLC

By: Adrian Melendez Jr., PM

Date: 3/22/2021

**PIS000075**